

Work Order ID 84753

May-22-12 3:00:38 PM

ASP - Rust

84753

Page 1

Item ID: D2348

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 22/05/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 29/05/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: *MJS*

Date: *12/05/12*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2348

Rev C

100

0.00

1.00

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2348

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

24 0 JM 12-5-23

110

0.00

1.10

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

24 0 JM 12-5-23

120

0.00

1.20

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5.210/29

Conte 124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Outsource process-Anodize per QSI017 4.1.10.1

0.00

150

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O:

17078

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

CL 12/05/30 24

160

Receive & Inspect for Damage & Mat'l Certs

0.00

160

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

440/31 (24)

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

INSPECT CERTS

5.17/6/34

counts
824

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 29/05/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

180

Small Fab

0.00

Small Fab

Memo

Small Fab

Install Insert as per Dwg D2348

QC5- Inspect part completeness to step on W/O

0.00

190

Memo

0.00

QC

Quality Control

Identify as per dwg & Stock Location: +

0.00

200

Memo

0.00

Packaging

Packaging

W/O: 84753		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2348 PAR #: _____ Fault Category: Sn Tab NCR: Yes No DQA: Yes Date: 12/06/07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 12/06/07

NCR: 12.1470		WORK ORDER NON-CONFORMANCE (NCR) 8.59						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.05.31	190	Insert was to crimped into Material. Process error; insert defect	UP 12.05.31	Scrap 1 qty + Destroy	SN 12/05/31	12/05/31	12.05.31	12.05.31

NOTE: Date & initial all entries

Work Order ID 84753

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Page 4

May-22-12 3:00:38 PM

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Required Date: 29/05/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

210

QC

Memo

Quality Control

0.00

12/5/31
MK
12-05-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-22-12 3:00:42 PM

Page 1

Work Order ID: 84753

84753

Parent Item: D2348

D2348

Parent Item Name: Wearplate

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased				100	sf	710.0922	0.0198	0.500211			

M6061T6S 063

**

6061-T6 .063 Sheet

Location	Loc Qty	Loc Code
MAT021	710.0922000	
113608	0	
116308	6.01556842	
117285	67.544	
119331	44.2	
119802	18.94	
120218	19.5	
120866	66.9426316	
121578	6.95	
121805	480	

D3996-FE-832-EF

Manufactured No

180 Each 151.0000 4

96

D3996-FE-832-EF

Self-Clinching Fastener

**

Location	Loc Qty	Loc Code
GA	150	
77489	.38	
82502	112	
ST285	1	
71756	1	

121805

24

FF 12-05-31

39
57

W/O:		WORK ORDER CHANGES					
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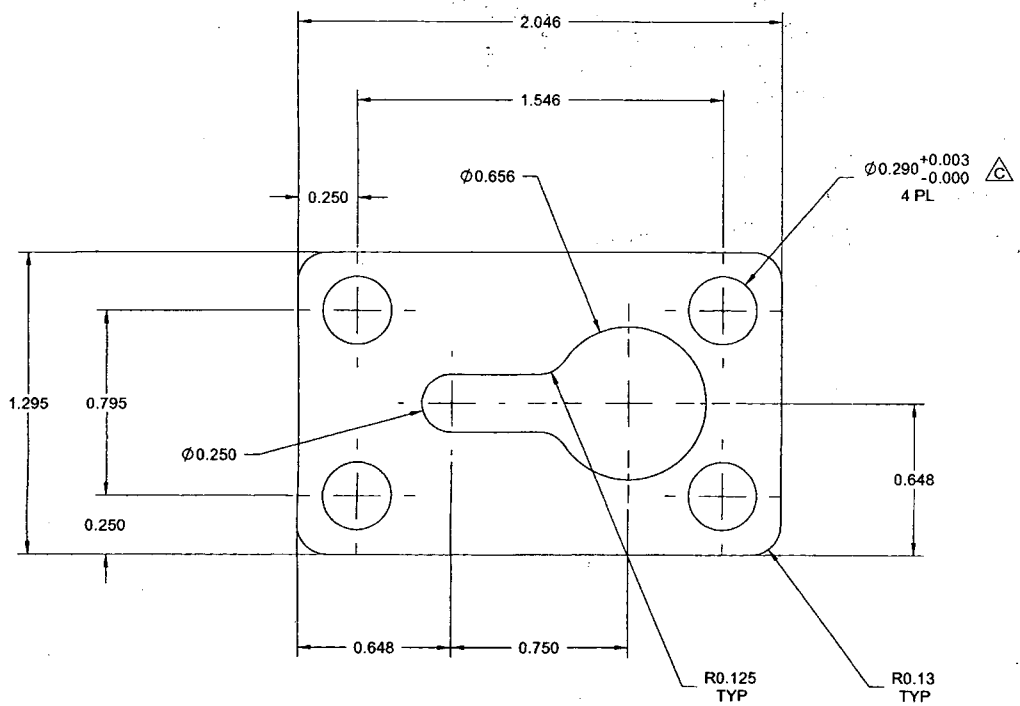
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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8 7 6 5 4 3 2 1



D2348F FLAT PATTERN

RELEASED
2009-11-08
ND

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/III CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348F" USING REMOVABLE TAG
 - 7) WEIGHT: 0.01 lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.	ND	D2348	SHEET 2 OF 2
APPROVED	ND	TITLE	SCALE
DE APPR.	ND	WEAR PLATE	NTS
DATE	09.10.01	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17078

Purchase Order Date 5/30/12

PO Print Date 5/30/12

Page Number 1 of 1

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

613-446-4544

613-446-4556

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
email

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
84753		D2348 WEARPLATE	6/04/12 Yes	24.00		\$3.7500	\$90.00

Special Inst: BLACK ANODIZE AS PER DWG D2348
REV. C
B84753
ANODIZE PER MIL-A-8625F TYPE I OR
IB OR IC
OR II OR IIB CLASS 2

PO Total:

\$90.00

Rush

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

Change Nbr: 1

Change Date: 5/30/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 61754

Date: 30-May-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms	Ship Via
-------	----------

Quantity	Description
----------	-------------

1
lot
Part: D2348 WEARPLATE
24 PCS
BLACK ANODIZE
MIL-A-8625 TYPE 2 CLASS 2

Rev:

MINIMUM RUN

Job: 20120336

PO: PO17078

Line:


8/2/13/

Certificate of Conformance

A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.

ISO 9001 : 2008 REGISTERED
ATG SALES-2010 TERMS APPLY

DATE: 30/5/12

CERTIFIED SIGNATURE: 

RECEIVER SIGNATURE: _____